

Work Order ID 82620

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82620

Page 1

Item ID: D412-698-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cabin Door Roller, RH

Stop

NS2

Start Date: 03/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/03 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100

100

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

DAS
16
9-6

12/04/17

MLJ 12/07/17

2

110

110

Packaging

Packaging

Pick Kit

0.00

2x

80
12-7-17

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

DAS
16
9-6

8 12/04/17

2

12-7-17

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-698-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cabin Door Roller, RH

Start Date: 03/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

0.00

(22)

12/7/17

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-698-012
Location: _____

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MCJ 12/07/17

MCJ 12/07/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 82620

82620
D412-698-012

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 03/04/2012

Required Date: 18/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from
Step 1,3KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3121-141 <i>*D3121-141*</i> Bracket Assembly		Manufactured	No		110	Each	12.0000	3	6	<i>Sx</i>	<i>84414</i>	
								**		<i>B83457</i>		

Location Loc Qty Loc Code

ST235 12

80097 12

110 Each

5.0000

3

6

Sx

B83457

D3121-144 <i>*D3121-144*</i> Bracket Assembly		Manufactured	No		110	Each	5.0000	0	2		<i>84412</i>	
								**				

Location Loc Qty Loc Code

ST235 4

79311 4

ST235A 1

75032 1

110 Each

6.0000

0

2

84412

D3137-043 <i>*D3137-043*</i> Bracket Assembly		Manufactured	No		110	Each	6.0000	1	2		<i>B83452</i>	
								**				

Location Loc Qty Loc Code

ST235B 6

79734 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 82620

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

82620
D412-698-012

Start Date: 03/04/2012

Start Qty: 2.00

Required Date: 18/04/2012

Required Qty: 2.00

D3183-044

Manufactured No 110 Each 2.0000

**

2
B8268840

D3183-044

Bracket Assembly

Location Loc Qty Loc Code

ST -4

ST235B 6

75034 2

D3199-1

Manufactured No 110 Each 12.0000

**

9 18
3x B838 (ad Sp
15x B832 67

D3199-1

Bracket

Location Loc Qty Loc Code

ST236 17

78618 4

79797 8

ST236A -5

D3202-1

Manufactured No 110 Each 8.0000

**

9 2
B83504 1x

D3202-1

Cover

Location Loc Qty Loc Code

ST241A 8

70294 8

B82663 1x

12-7-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
			7			D3121-21	BOLT
			5			D3121-241	BEARING ASSEMBLY
			1			D3137-3	GUIDE
			1			D3137-5	WASHER
			2			D3183-045	BEARING ASSEMBLY
				3		D3238-1	SHIM
				1		D3238-3	SHIM
				2		D3238-5	SHIM
				6		D3238-11	SHIM
				2		D3238-13	SHIM
				4		D3238-15	SHIM
			8			AN960JD416L	WASHER
			8			MS21042L4	NUT (OR MS21042-4)
			16			MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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